

Work Order ID 128651***128651***

Page 1

Item ID: D3322-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pod Assembly

Start Date: 1/21/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/21/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLSDate: 1501-21 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2202

REV G

D3322

Rev A

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 27219

Description:

D2202-1 Pod Lid D2202-5 Pod Base

Supplier: Delastek

Copy of Certificate of Conformity and Process sheet from Delastek is required

SHIP TO DELASTEK QTY (1) D3048-1

QTY (3) D3001-1

MLS 1501-26

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity and process sheet from Delastek is attached

1X SP15-03-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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128651

Wednesday, January 21, 2015 7:39:34 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/21/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/21/2015 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order ID 128651

128651

Page 3

Wednesday, January 21, 2015 7:39:34 AM

Item ID: D3322-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pod Assembly

Start Date: 1/21/2015 Start Qty: 1.00

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Cust Item ID:

Required Date: 1/21/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>(supplies)</i>	0.00							
150									
Packaging	Memo	0.00							<i>15-04-08</i>
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							<i>MLJ 15-04-10</i>
Quality Control									

15-4-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, January 21, 2015 7:39:40 AM

Page 1

Work Order ID: 128651

128651

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/21/2015

Required Date: 1/21/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A04.11.12New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L06		Purchased	No			100	Each	563.0000	2	2			

MS210421 06

Nut

**

15-06-06

Location	Loc Qty	Loc Code
ST304	350	
m131294	50	
m131317	300	
ST305	213	
m129499	13	
m130325	200	

D2202-1P

Purchased

No

110

Each

0.0000

1

1

D2202-1P

Side Pod Lid, 350

**

1x 8015-03-30

D2202-5P

Purchased

No

110

Each

0.0000

1

1

D2202-5P

Side Pod, Base 350

**

1x 8015-03-30

D3001-1

Manufactured

No

110

Each

3.0000

3

3

D3001-1

Doubler

**

CD15/01/27

Location	Loc Qty	Loc Code
ST487	3	
113456	3	

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, January 21, 2015 7:39:40 AM

Page 2

Work Order ID: 128651

128651

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/21/2015

Required Date: 1/21/2015

Start Qty: 1.00

Required Qty: 1.00

D3048-1 Manufactured No

110 Each

1.0000

1 1

D3048-1

Doubler

**

Call 1/11/27.

Location

Loc Qty

Loc Code

CA2

1

52263

1

B100618 x1

AD62ABS Purchased No

130 Each

123.0000

38

38

AD62ARS

rivet

**

AT 15-04-06

Location

Loc Qty

Loc Code

st549

123

m128211

23

m128454

100

x78

AD64ABS Purchased No

130 Each

347.0000

43

43

AD64ARS

Pop Rivet

**

AT 15-04-06

Location

Loc Qty

Loc Code

CCK004

262

M128728

262

st549

85

M128728

85

x43

AD66ABS Purchased No

130 Each

284.0000

2

2

AD66ARS

Pop Rivet

**

AT 15-04-06

Location

Loc Qty

Loc Code

st549

284

112784

284

x2

Wednesday, January 21, 2015 7:39:40 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Wednesday, January 21, 2015 7:39:40 AM

Page 3

Work Order ID: 128651

Parent Item: D3322-041

Parent Item Name: Pod Assembly

128651

D3322-041

Start Date: 1/21/2015

Required Date: 1/21/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-5A Purchased No 130 Each 110.0000 19 19

AN4-5A

BOLT

131800 x 12

**

ET 15-07-06

Location	Loc Qty	Loc Code
CA	106	
m129682	106	x7
ST346	4	
106605	1	
120562	2	
15247	1	

AN4-6A Purchased No 130 Each 2,144.000 1 1

AN4-6A

BOLT

**

ET 15-07-06

Location	Loc Qty	Loc Code
ST325A	2093	
16067	2	
M126317	91	
M128634	100	x1
M130716	200	
M130851	100	
M131153	1600	
ST345	51	
M128403	51	

AN526C632R7 Purchased No 130 Each 157.0000 2 2

AN526C632R7

Screw

**

ET 15-07-06

Location	Loc Qty	Loc Code
ST329	157	
m129339	157	x2

Wednesday, January 21, 2015 7:39:41 AM

Shop Packet Print

Page 3

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Picklist Print

Wednesday, January 21, 2015 7:39:41 AM

Page 4

Work Order ID: 128651

128651

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/21/2015

Required Date: 1/21/2015

Start Qty: 1.00

Required Qty: 1.00

D2204-9 Manufactured No

130

Each

9.0000

5

5

D2204-9

Rubber Latches

130319

**

ET 15-04-06

Location

Loc Qty

Loc Code

ST488a

9

126168

9

D2429-041

Manufactured No

130

Each

14.0000

1

1

D2429-041

Spring Clip Ass'Y

**

ET 15-04-06

Location

Loc Qty

Loc Code

ST007

14

107585

4

124757

10

D2462

Manufactured No

130

f

507.8000

14.17

15

D2462

Seal (Per foot)

9/15/07
D2462

B 128447

**

ET 15-04-07

Location

Loc Qty

Loc Code

CA2

0.8

48530

0.8

ST409

7

98802

7

ST638

500

115832

500

D2528-1

Manufactured No

130

Each

9.0000

5

5

D2528-1

Backer Plate

128878 x1

**

ET 15-04-06

Location

Loc Qty

Loc Code

ST007

9

113711

9

x4

Wednesday, January 21, 2015 7:39:41 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, January 21, 2015 7:39:41 AM

Work Order ID: 128651

128651

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/21/2015

Required Date: 1/21/2015

Start Qty: 1.00

Required Qty: 1.00

D2528-3 Manufactured No 130 Each 19.0000 4 4

D2528-3

Backer Plate

**

FI 15-04-06

Location Loc Qty Loc Code

ST007 19

110938 19

D2569 Manufactured No 130 Each 4.0000 1 1

D2569

Hinge

**

FI 15-04-06

Location Loc Qty Loc Code

CA2 4

113832 1

125408 3

D3007-041 Manufactured No 130 Each 3.0000 1 1

D3007-041

Prop Assy

**

FI 15-04-06

Location Loc Qty Loc Code

ST368 3

120205 1

124758 1

125141 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, January 21, 2015 7:39:41 AM

Work Order ID: 128651

128651

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/21/2015

Required Date: 1/21/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

130

Each

3,080.000

20

20

MS21042L4

Locknut

131803

**

15-04-06

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

704

m127813

704

ST260a

1769

m130799

1769

ST305

541

15924

8

426

426

m128300

8

m130922

99

NAS1149D0463J

Purchased

No

130

Each

5,134.000

21

21

NAS1149D0463J

WASHER

131624

**

15-04-06

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1167

16941

14

M129390

1153

ST269

3114

M129390

12

M130799

3102

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 7

Wednesday, January 21, 2015 7:39:41 AM

Work Order ID: 128651

128651

Parent Item: D3322-041

D3322-041

Parent Item Name: Pod Assembly

Start Date: 1/21/2015

Required Date: 1/21/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN632J

Purchased

No

130

Each

248.0000

2

2

NAS1149DN632.J

**

15-04-06

Washer

Location

Loc Qty

Loc Code

ST270

248

M127255

100

M128812

148

x2

Wednesday, January 21, 2015 7:39:41 AM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816,
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,
OR DIVINYCELL,
OR AIREX,
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

- 2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2
OUTSIDE = WHITE GELCOAT #GEL 944W005
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LAMINATE PER DART QSI 006.
LAMINATION SCHEDULE PER THIS DRAWING.
- 9) PEEL PLY ALL SURFACES.

128651 M.C.3
150121

RELEASED
2010-10-28

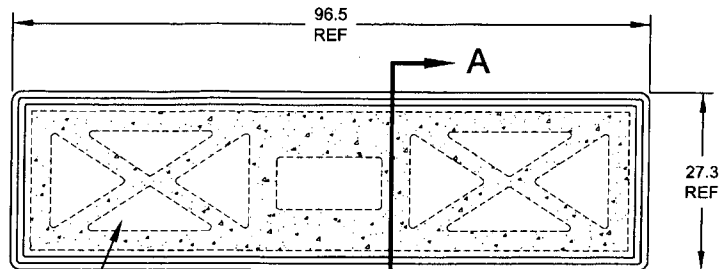
G	REFORMAT DRAWING TO CURRENT STANDARDS; D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5/-6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

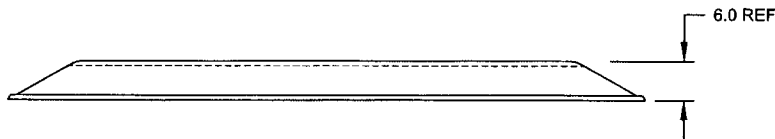
D

SEE
DETAIL B
A6-2

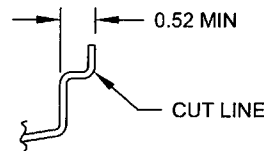


SECTION A-A C3-2

G
D2202-101 FOAM CORE,
MAKE FROM 3/8" FOAM, ROUTER PER DT8024



D2202-1 LID
(MOLD DT8002)



DETAIL B
SCALE 10X C6-2

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-101 FOAM CORE
5oz KEVLAR
9oz SATIN

G

RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 2 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

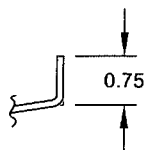
A

A

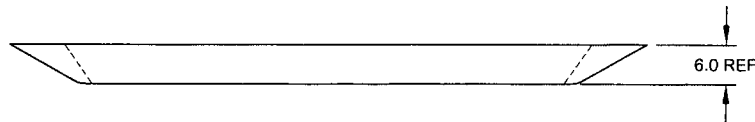
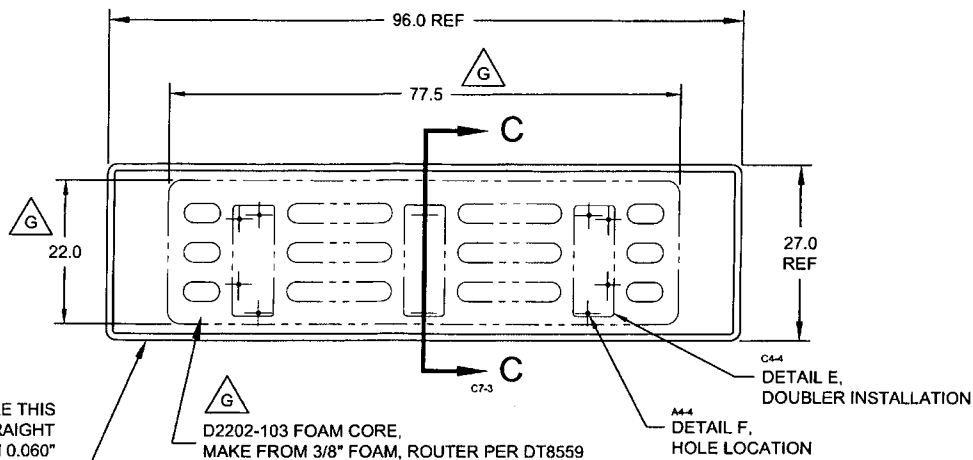
SEE
DETAIL D
B7-3

SECTION C-C C4-3

ENSURE THIS
EDGE IS STRAIGHT
WITHIN 0.060"
AFTER TRIMMING



DETAIL D
SCALE 10X D7-3



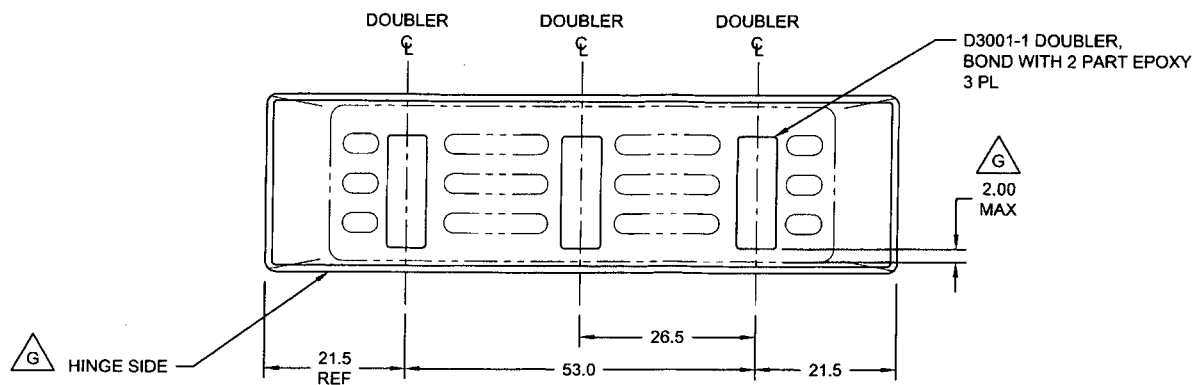
D2202-3 BASE
(MOLD DT8002)

MAIN LAYUP

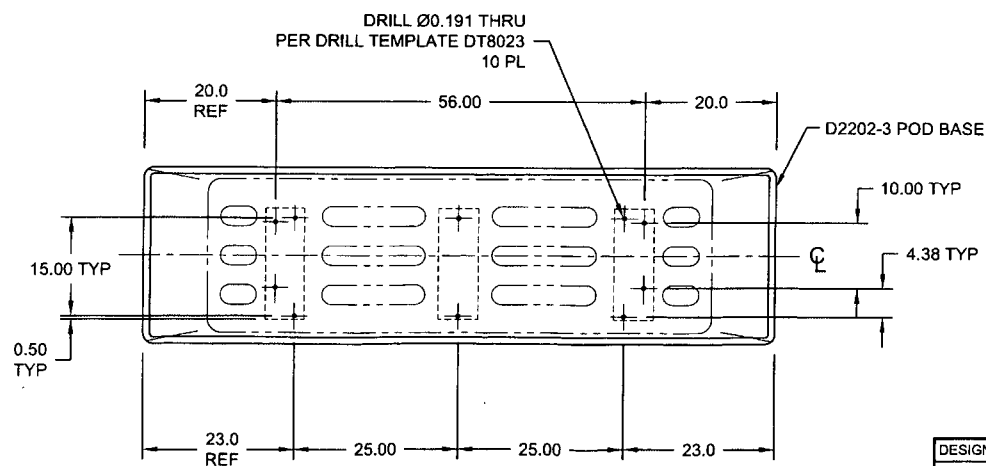
9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-103 FOAM CORE
5oz KEVLAR
5oz KEVLAR
9oz SATIN

RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 3 OF 5
APPROVED	<u>142</u>	TITLE	SCALE
DE APPR.	<u>14</u>	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DETAIL E: INSTALLATION OF D3001-1 DOUBLERS C3-3



DETAIL F: HOLE DRILLING C3-3
(AFTER DOUBLER INSTALLATION)

RELEASED
2010-10-28

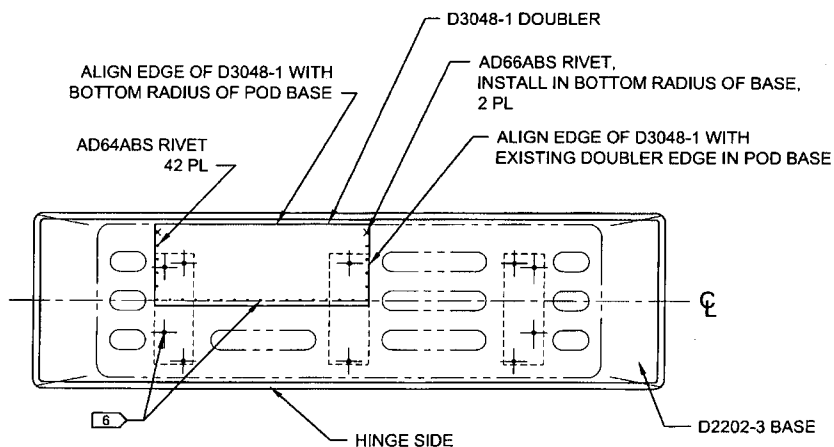
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES : TO MAKE A D2202-5-6 BASE (FOR D350-602-013-014) FROM A D2202-3 BASE

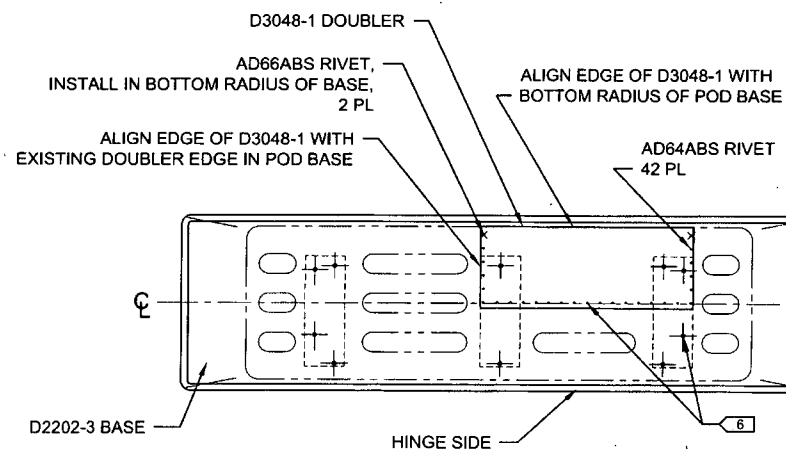
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE.
INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

PART LIST:

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



D2202-5 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)



D2202-6 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)

RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 5 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

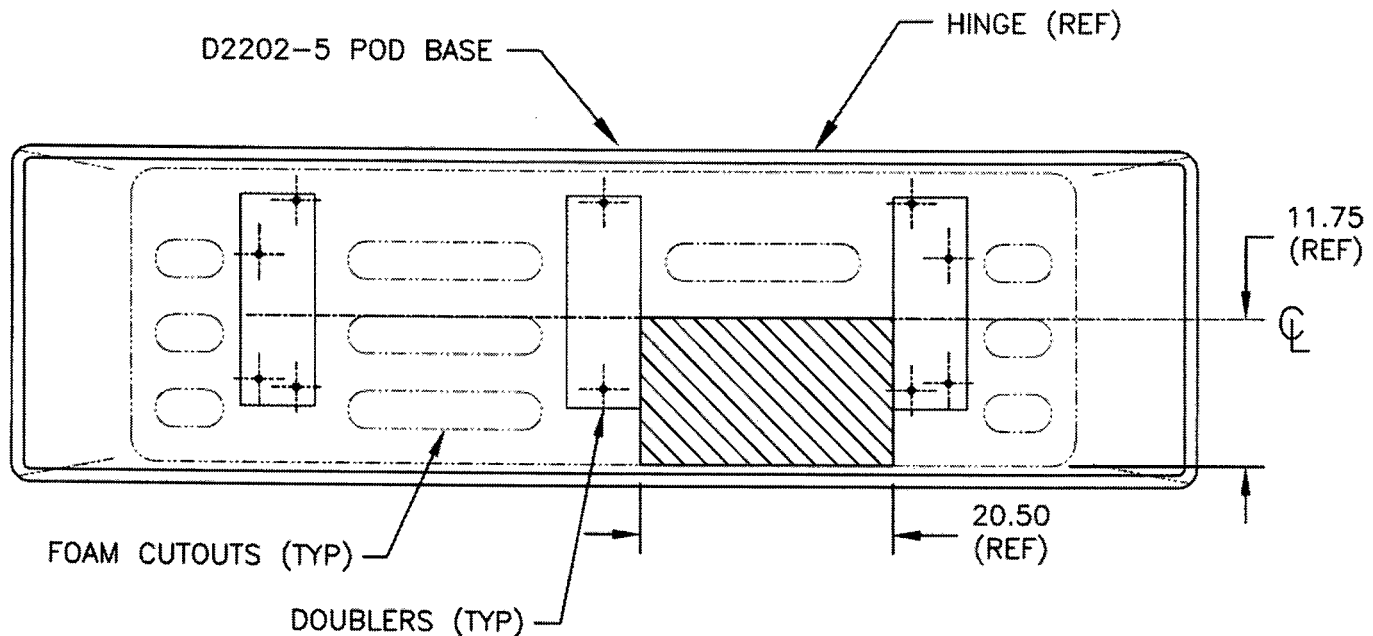


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3322	REV. A SHEET 1 OF 1
DATE 04.09.26		TITLE POD ASSEMBLY	SCALE 1:15
A	04.09.26	NEW ISSUE	

RELEASED
04.10.29 *[Signature]*

D3322-041/-042 POD ASSEMBLY

- 1) THE D3322-041/-042 POD ASSEMBLIES ARE THE SAME AS THE D2694 POD ASSEMBLIES, EXCEPT THE D2202-3 POD BASE IS REPLACED WITH THE D2202-5 POD BASE



D3322-041 POD ASSEMBLY (SHOWN)
D3322-042 POD ASSEMBLY (OPPOSITE)

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27219**

Purchase Order Date 1/26/2015

PO Print Date 1/26/2015

Page Number 1 of 2

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	819 533 5788	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 30
Ship Via:	FedEx Overnight collect	Currency	USD
Ship Acct:		FOB	FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2202-1P AS PER DWG. D2202 REV.G B128651	Side Pod Lid, 350	2/16/2015 Yes 2/16/2015		1.00 Each	\$2,890.60	\$2,890.60

Line Total: \$2,890.60

2	D2202-5P AS PER DWG. D2202 REV.G B128651	Side Pod, Base 350	2/16/2015 Yes 2/16/2015		1.00 Each	\$2,890.60	\$2,890.60
---	--	--------------------	-------------------------------	--	--------------	------------	------------

Line Total: \$2,890.60

SPS-03-30

Note:

1/26/2015



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	59679
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
25-03-2015	27-01-2015	25463	Chantal Lavoie	PO27219	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Fedex Int. Eco. Coll.	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0073	Line #1 D2202-1 Side Pod Lid B128651 Référence DKA362-0015 DWG: REV. G	U of M: Chaque
				Lot # 67290	1
1	0	1	DKC134-0075	Line #2 D2202-5 Side Pod Base B128651 DWG: D2202 Rév.: G	U of M: Chaque
				Lot # 67291	1
			DOCUMENTS INCLUDED	SAS-03-30	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

M. A. H. *A. J. O. H.* AQ-357

Quality department

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Lundi, 2015-02-09 13:24:11
Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 67291
Numéro Soumission : 4345
Numéro B.A. :
Cette fois : 2015-02-09 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 63010

Nom Dessin : UTILITY POD BASE
Numéro Article : DKC134-0075
Numéro Dessin : D2202
Projet Numéro : DK-362
Révision dessin : G
Matériel : Resine Darakane 470-36/411/510
Date Dûe : 2015-04-06 Qté: 1 Udm: UNITE



Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de Pièce Client: D2202-5

COPIE

Process Sheet Rév.: 02 AAC1885 était AC0883, AAC1887 était AC0884

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Commentair Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 4802810AA

2.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule DKO-0331 selon IF134-0011.

Date: 18/02/15 Sceau:



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.250 KILOGRAMME(s)/Unit Total : 1.250 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 4907730AA

4.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0095 GALLON(s)/Unit Total : 0.0095 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer le Gel Coat sur le moule selon IF134-0011

Date: 18/02/15 Sceau:



Date: Lundi, 2015-02-09 13:24:11
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD BASE	
Numéro Job: 67291		Numéro Article: DKC134-0075	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Commentair Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)		9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-46418-1	
7.0	AAC1885	Tissu à délaminer Release ply B	
Commentair Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)		# de Lot: N/A	
8.0	AAC1608	5oz plain weave Kevlar 50" wide roll	
Commentair Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s)		5oz plain weave Kevlar 50" wide roll N° de Lot: 1-42765-1	
9.0	AAC1887	Wrightlon 5200 Bleu P3	
Commentair Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)		Wrightlon 5200 Bleu P3 # de Lot: N/A	
10.0	AC0885	Feutre de drainage N° Airweave N 10	
Commentair Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)			
11.0	AC0943	Stretchlon 200 poche à vide Vert	
Commentair Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)			
12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Commentair Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)			
13.0	AC1091	Film durisol # 3001792	
Commentair Qty.: 12.50 METRE CAR(s)/Unit Total : 12.50 METRE CAR(s)			
14.0	TAILLAGE	Faire le tailage du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le tailage du matériel et le matériel pour le Bagging selon IF 134-0011.			
Date: 17/02/15		Sceau: 	
15.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)		Résine (411B7530) 411-350 promo. 75min. N° de Lot: 4925810AA	
16.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)		Catalyst N° DDM-9 N° de Lot: 1-27829-1	
17.0	LAMINAGE	Faire le laminage	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le laminage des tissus(verre et Kevlar) selon IF134-0011.			
Date: 18/02/15		Sceau:  	

Date: Lundi, 2015-02-09 13:24:11
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 67291

Nom Dessin: UTILITY POD BASE
Numéro Article: DKC134-0075

Numéro Job:



Séq.: Machine ou Opération: Description :

18.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 3:00 Heure Fin Curing: 8:00

Date: 18/02/15 Sceau:



19.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27824-1 4925810AA

20.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0 DKC134-0021 D2202-103 Foam Core (Utility pod Base)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
D2202-103 Foam Core (Utility pod Base) N° de Job: 67364

22.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sceller le Foam Core N° DKC134-0021 selon IG 0105.

Date: 19-02-15 Sceau:



23.0 AAC1611 Polybond B46F

Commentair Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)
Polybond B46F N° de Lot: 1-44904-1

24.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Positionner et coller le Foam Core N° DKC134-0021 selon IF134-0011.

Date: 23/02/15 Sceau:



Date: Lundi, 2015-02-09 13:24:11
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 67291

Nom Dessin: UTILITY POD BASE
Numéro Article: DKC134-0075

Numéro Job:



Séq.: Machine ou Opération: Description :

25.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 11:00
Date: 23/02/15 Sceau: 56

Heure Fin Curing: 12:30
Sceau: 73

26.0 DECOUPE Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la découpe manuelle du foamcore selon IF134-0011 point 8.5.

Date: 27/02/15 Sceau: 56



27.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 4925810AA

28.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

29.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des derniers tissus selon IF134-0011.

Date: 27/02/15 Sceau: 4297 A.M



30.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 3:00
Heure Fin Curing: 8:00

Date: Lundi, 2015-02-09 13:24:11
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD BASE	
Numéro Job: 67291		Numéro Article: DKC134-0075	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description:	
	Date: 27/02/15 Sceau: 4297 A.M	 	
31.0	AAC1615	D3001-1 Doubler (Pod Base D2002-3)	
Commentair Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s)		N° de Lot: 4949120AA	
D3001-1 Doubler (Pod Base D2002-3)			
32.0	AAC0102	Colle Araldite N° 2012 (50ml)	
Commentair Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s)		N° de Lot: 4829510AA	
Colle Araldite N° 2012 (50ml)			
33.0	ASSEMBLAGE	Assemblage mécanique	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Coller les trois doubler N° D3001-1 selon IF134-0011.			
Faire trois petites poches à vide selon IG 0012.			
Laisser sécher pendant 4 heures minimum.			
Heure début Curing: 11:00		Heure Fin Curing: 3:00	
Date: 2/03/15 Sceau:		 	
34.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Commentair Qty.: 0.030 GALLON(s)/Unit Total : 0.030 GALLON(s)		# de Lot: 4806910AA	
N° P-15-3, Adtech Micro Ultra Filler			
35.0	FINITION	Finition Générale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Retirer les trois poches à vide et faire un joint tout autour des trois doubler à l'aide du "Filler" P15-3 et laisser sécher.			
Date: 2/03/15 Sceau:		 	
36.0	AAC1680	D3048-1 Doubler	
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)		N° de Lot: 4949110AA	
D3048-1 Doubler			
37.0	LAMINAGE	Faire le laminage	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le laminage des tissus pour épaissir et installer le grand doubler selon IF134-0011.			
Date: 2/03/15 Sceau:		 	

Date: Lundi, 2015-02-09 13:24:11
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD BASE	
Numéro Job: 67291		Numéro Article: DKC134-0075	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
38.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Commentair Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s)		# de Lot: 4808910AA	
N° P-15-3, Adtech Micro Ultra Filler			
39.0	FINITION	Finition Générale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la finition de l'intérieur selon IG 0043.			
Vérifier la surface intérieure du Pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine aux endroits où il y a des bulles d'air.			
Corriger les imperfections de surface à l'aide du "Filler" P15-3.			
Laisser sécher jusqu'au lendemain			
Date: 05-03-15 Sceau:  			
40.0	DÉMOULAGE	Démoulage de la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager la pièce.			
Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide d'un manche de tournevis.			
Date: 3/03/15 Sceau:  			
41.0	TRIMAGE	Trimage	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le trimage selon IF134-0012.			
Date: 4/03/15 Sceau: 			
42.0	AAC1021	Dupont Primer N° 7704S	
Commentair Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s)		N° de Lot: 4768450AA	
Dupont Primer N° 7704S			

Date: Lundi, 2015-02-09 13:24:11
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD BASE	
Numéro Job: 67291		Numéro Article: DKC134-0075	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>4768410AA</u>			
44.0	PRIMER	Application primer	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: <u>06/03/15</u> Sceau:  # de Fiche technique: <u>10629</u>			
45.0	FINITION	Finition Générale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Ponçer le "Primer" batisseur selon IG 0008. Date: <u>16-03-15</u> Sceau: 			
46.0	AAC1021	Dupont Primer N° 7704S	
Commentair Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>4768450AA</u>			
47.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>4768410AA</u>			
48.0	PRIMER	Application primer	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: <u>15/03/15</u> Sceau:  <u>10637</u>			
49.0	INSPEC FINAL	Inspection finale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin. Date: <u>19/03/15</u> Sceau: 			

Date: Lundi, 2015-02-09 13:24:11
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD	Nom Dessin: UTILITY POD BASE
Numéro Job: 67291	Numéro Article: DKC134-0075

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

50.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0007

Date: 25/3/15 Sceau:



Date: Lundi, 2015-02-09 13:24:10
Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 67290
Numéro Soumission : 4347
Numéro B.A. :
Cette fois : 2015-02-09 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 62083
Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de Pièce Client: D2202-1

Nom Dessin : UTILITY POD LID
Numéro Article : DKC134-0073
Numéro Dessin : D2202
Projet Numéro : DK-362
Révision dessin : G
Matériel : Resine Darakane 470-36/411/510
Date Dûe : 2015-04-06 Qté: 1 Udm: UNITE

PL-1

COPIE

Process Sheet Rév.: 03 Ajout de la IF134-0008 à la séquence 35.0.

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Commentair Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 4802810AA

2.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule DKO-0331 selon IG 0009.

Date: 3/03/15 Sceau:



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.250 KILOGRAMME(s)/Unit Total: 1.250 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 4907730AA

4.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0095 GALLON(s)/Unit Total: 0.0095 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer le gel coat selon IG 0019.

Date: 3/03/15 Sceau:



Date: Lundi, 2015-02-09 13:24:10
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD LID	
Numéro Job: 67290		Numéro Article: DKC134-0073	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Commentaire Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: <u>1-4648-1</u>			
7.0	AAC1885	Tissu à délaminer Release ply B	
Commentaire Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s) Tissu à délaminer Release ply B # de Lot: <u>N/A</u>			
8.0	AAC1608	5oz plain weave Kevlar 50" wide roll	
Commentaire Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s) 5oz plain weave Kevlar 50" wide roll N° de Lot: <u>1-42765-1</u>			
9.0	AAC1887	Wrightlon 5200 Bleu P3	
Commentaire Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: <u>N/A</u>			
10.0	AC0885	Feutre de drainage N° Airweave N 10	
Commentaire Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)			
11.0	AC0943	Stretchlon 200 poche à vide Vert	
Commentaire Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)			
12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Commentaire Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)			
13.0	TAILLAGE	Faire le tailage du matériel	
			

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le tailage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule DKO-0331

Deux morceaux pour couvrir les extrémités du moule DKO-0331

Deux morceaux pour recouvrir les cotés du moule DKO-0331

Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide (Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Peel Ply
Film Durisol P-3
Feutre de drainage 6m
Stretchlon 200

Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

Date: Lundi, 2015-02-09 13:24:10
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD LID	
Numéro Job: 67290		Numéro Article: DKC134-0073	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
	Date: <u>26/02/15</u> Sceau:  		
14.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>499910 AA</u>			
15.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
16.0	PREP-GENERAL	Préparation du matériel	
 			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid : 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.			
Date: <u>3/03/15</u> Sceau:  			
17.0	LAMINAGE	Faire le laminage	
 			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Kevlar) de la façon suivante:			
Recouvrir toute la surface du moule DKO-0331 à l'aide de de résine Derakane 411-350 Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)			
Recommencer pour les deux autres plis. (un pli de 9 oz et un pli de 5 oz Kevlar)			
Date: <u>3/03/15</u> Sceau:  			
18.0	BAGGING	Faire le bagging sur la pièce	
 			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la poche à vide selon IG 0012			
Laisser sécher 4 heures minimum			
Date: <u>3/03/15</u> Sceau:  			

Date: Lundi, 2015-02-09 13:24:10

Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE LTD

Nom Dessin: UTILITY POD LID

Numéro Job: 67290

Numéro Article: DKC134-0073

Numéro Job:



Séq.:

Machine ou Opération:

Description :

19.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 41925810AA

20.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

21.0

DKC134-0022

D2202-101 Foam Core (Utility Pod Lid)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

D2202-101 Foam Core (Utility Pod Lid)

N° de Job: 67365

22.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 1.5% de catalyst DDM-9 par quantité de résine.

Date: 19-02-15 Sceau:



23.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sceller le Foam Core N° DKC134-0022 selon IG 0105.

Date: 19-02-15 Sceau:



24.0

AAC1611

Polybond B46F

Commentair Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)

Polybond B46F

N° de Lot: 1-44964-1

25.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG 0033.

Date: 4/03/15 Sceau:



26.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Date: Lundi, 2015-02-09 13:24:10
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD LID	
Numéro Job: 67290		Numéro Article: DKC134-0073	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.			
Heure début Curing: <u>10:45</u> Heure Fin Curing: <u>11:30</u>			
Date: <u>4/03/15</u> sceau:  			
27.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>4991910AA</u>			
28.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
29.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.			
Date: <u>12-03-15</u> Sceau:  			
30.0	LAMINAGE	Faire le laminage	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le laminage des deux dernier plis de tissu (1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:			
Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)			
Recommencer pour le dernier plis. (un pli de 9 oz)			
Date: <u>12-03-15</u> Sceau:  			
31.0	BAGGING	Faire le bagging sur la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la poche à vide selon IG 0012.			
Laisser sécher 4 heures minimum.			
Heure début Curing: <u>10.30</u> Heure Fin Curing: <u>8 00</u>			

Date: Lundi, 2015-02-09 13:24:10
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD LID	
Numéro Job: 67290		Numéro Article: DKC134-0073	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
	Date: <u>12-03-15</u> Sceau:  		
32.0	DÉMOULAGE	Démoulage de la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le démoulage du Utility Pod Lid en faisant bien attention de ne pas endommager la piece			
Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du manche d'un tournevis.			
	Date: <u>13/03/15</u> Sceau: 		
33.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Commentair Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s)			
N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>4808910AA</u>			
34.0	FINITION	Finition Générale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.			
Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munie d'une aiguille de la résine au endroit où il y a des bulles d'air.			
Corriger les imperfection de surface à l'aide du "Filler" P15-3 selon IG 0043			
Laisser sécher jusqu'au lendemain.			
	Date: <u>16-03-15</u> Sceau:  		
35.0	TRIMAGE	Trimage	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le trimage du Pod Lid selon la IF134-0008.			
	Date: <u>13/03/15</u> Sceau: 		
36.0	AAC1021	Dupont Primer N° 7704S	
Commentair Qty.: 0.4300 UNITE(s)/Unit Total : 0.4300 UNITE(s)			
Dupont Primer N° 7704S N° de Lot: <u>4768450AA</u>			

Date: Lundi, 2015-02-09 13:24:10
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD LID	
Numéro Job: 67290		Numéro Article: DKC134-0073	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>4768410AA</u>			
38.0	PRIMER	Application primer	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer un couche de primer bâtisseur selon IG 0008 Date: <u>19/03/15</u> Sceau:  # Fiche de Mélange: <u>10637</u>			
39.0	FINITION	Finition Générale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le sablage au grit 180 de la surface primé pour enlever les imperfections restantes. Date: <u>19-03-15</u> Sceau:  			
40.0	AAC1021	Dupont Primer N° 7704S	
Commentair Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>4768450AA</u>			
41.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>4768410AA</u>			
42.0	PRIMER	Application primer	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008 Date: <u>23/03/15</u> Sceau:  # Fiche de Mélange: <u>10640</u>			
43.0	INSPEC. FINAL	Inspection finale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin. Date: <u>21/03/15</u> Sceau: 			

Date: Lundi, 2015-02-09 13:24:10
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: UTILITY POD LID	
Numéro Job: 67290		Numéro Article: DKC134-0073	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
44.0	EMBAL / ENTREPO	Emballage & Entreposage	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Emballer et entreposer selon IG 0057			
Date: 25.03.15 Sceau: 			